

Work Order ID 126538 -2

Thursday, November 13, 2014 8:31:23 AM

Ship NOV. 21

126538

Page 1

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 11/17/14 Start Qty: 25.00

Required Date: 11/20/14 Req'd Qty: 25.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 14-11-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3779	C								

100

100

Waterjet

FLOW CNC Waterjet

6061 .125"

FLOW WATER JET

0.00

Memo

0.00

1-Cut D3779-5 as per Dwg D3779

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

DAS

23

9-89

14-11-12

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

DAS

23

9-89

14-11-12

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

DAS

38

9-89

NOV 13 2014

Work Order ID 126538

Thursday, November 13, 2014 8:31:23 AM

126538

Page 2

Item ID: D3779-043

Accept

Revision ID:

N900040100

Item Name: Handle Assembly (Interior)

Setup Start *NS1*

Start Date: 11/17/14 Start Qty: 25.00

Stop *NS2*

Required Date: 11/20/14 Req'd Qty: 25.00

25

Cust Item ID:

25

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

NR1

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

0.00

Memo

0.00

1- counter sink holes as per dwg D3779
2- deburr

28

14/11/17

DAS
36
9-89

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(28)

38
9-89

NOV 17 2014

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

28. 14-11-18

DAS
34
9-89

Work Order ID 126538

Thursday, November 13, 2014 8:31:23 AM

126538

Page 3

Item ID: D3779-043

Accept

Revision ID:

N900040100

Item Name: Handle Assembly (Interior)

Setup Start ***NS1***

Start Date: 11/17/14 Start Qty: 25.00

Stop ***NS2***

Required Date: 11/20/14 Req'd Qty: 25.00

25

Cust Item ID:

25

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DAS
30
9-89

28

14/11/14

180

Small Fab

0.00

180

Small Fab

Memo

0.00

1- rivet D3203-1 handle to D3779-5 plate as per dwg D3779 per QSI003

3

FF

NOV 19 2014

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

(3)

DAS
38
9-89

NOV 19 2014

Work Order ID 126538

Thursday, November 13, 2014 8:31:23 AM

126538

Page 4

Item ID: D3779-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Handle Assembly (Interior)

Start Date: 11/17/14 Start Qty: 25.00

25

Required Date: 11/20/14 Req'd Qty: 25.00

25

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject
Qty Qty
Number Insp.
Stamp

200

Identify as per dwg & Stock Location: *St-034*

0.00

200

Packaging

Memo

PPP 126534

0.00

Packaging

43

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

14/11/20

4-11-19

Picklist Print

Thursday, November 13, 2014 8:31:30 AM

Page 1

Work Order ID: 126538

126538

Parent Item: D3779-043

D3779-043

Parent Item Name: Handle Assembly (Interior)

Start Date: 11/17/14

Required Date: 11/20/14

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-07-21 procedure change DD verified by:EC IPP Rev:C
11.12.02 as per dwg revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	149.3910	0.4365	12			
M6061T6S 125													
6061-T6 .125 Sheet													

Location

Loc Qty

Loc Code

MAT021

149.391

m127272

29.2

m127454

24.703

m127501

5.1

m128852

6.938

m130524

21.45

m130745

62

D3203-1

Manufactured No

180

Each

17.0000

1

25

D3203-1

Handle

Location

Loc Qty

Loc Code

ST490

17

126443

17

MS20426AD10-9A

Purchased No

180

Each

118.0000

4

100

MS20426AD10-9A

RIVET

Location

Loc Qty

Loc Code

ST311

118

125170

1

M127659

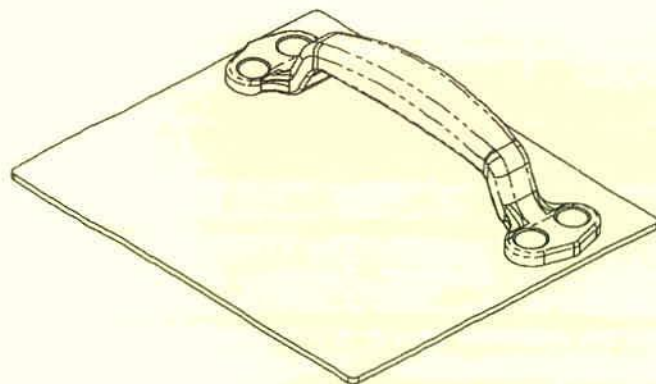
17

M130862

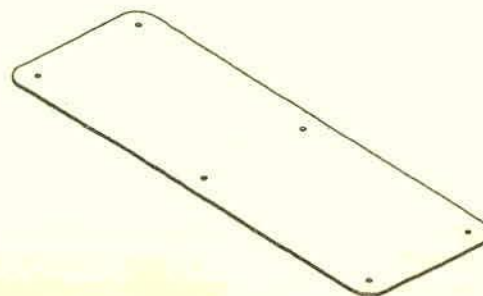
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12

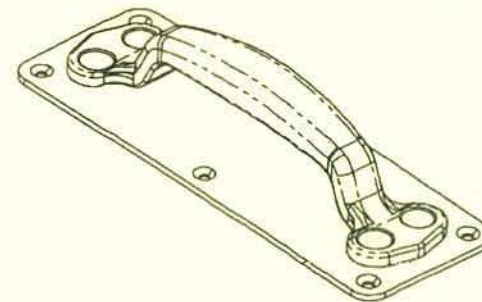
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
1		D3779-7	HANDLE
4	4	MS20426AD10-9A	RIVET, CSK



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**



D3779-3 DOUBLER PLATE



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: (SEE SHEETS 2 & 3)
 - 7) WEIGHT: D3779-3: 0.14 lbs
D3779-041: 0.71 lbs
D3779-043: 1.14 lbs

Handwritten: 126538

RELEASED
2012-07-23

REV.	DESCRIPTION	BY	DATE
C	CHANGED RIVET FROM -8 TO -9A CHANGED D3779-041 FROM FLAT TO CONTOURED	RP	12.04.26
B	REFORMAT IAW DART QSI 043; MS20426AD10-9 WAS MS20426AD10-8 (ZN D6-1, B954-2) PRODUCTION FACILITY (PAR11-136)	MB	11.11.24
A	NEW ISSUE	AJS	08.04.21
DESIGN	AJS		
DRAWN	RP		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.26		

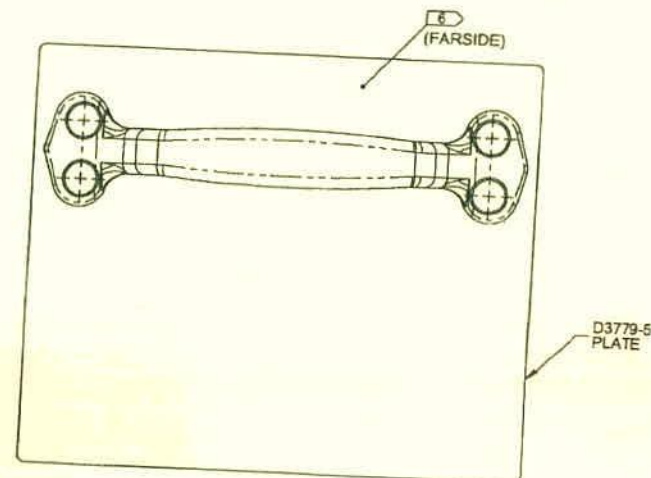
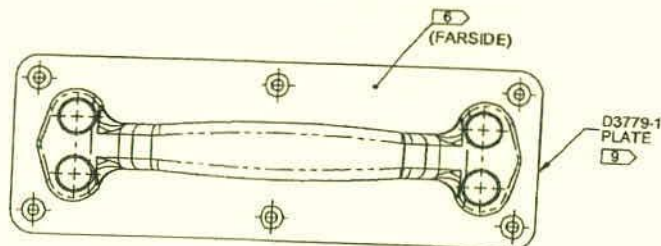
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3779

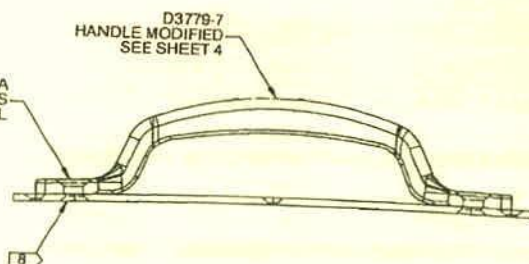
TITLE
**HANDLE ASSEMBLY,
CABIN SLIDING DOOR**

REV. C
SHEET 1 OF 4
SCALE
NTS

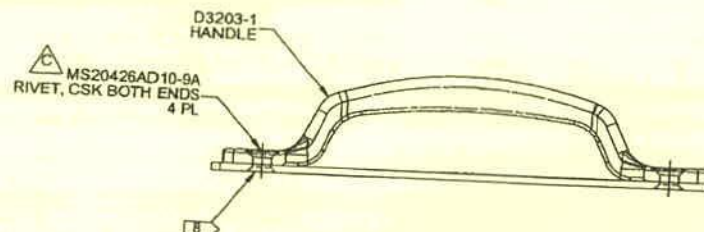
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MS20426AD10-9A
RIVET, CSK BOTH ENDS
4 PL



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



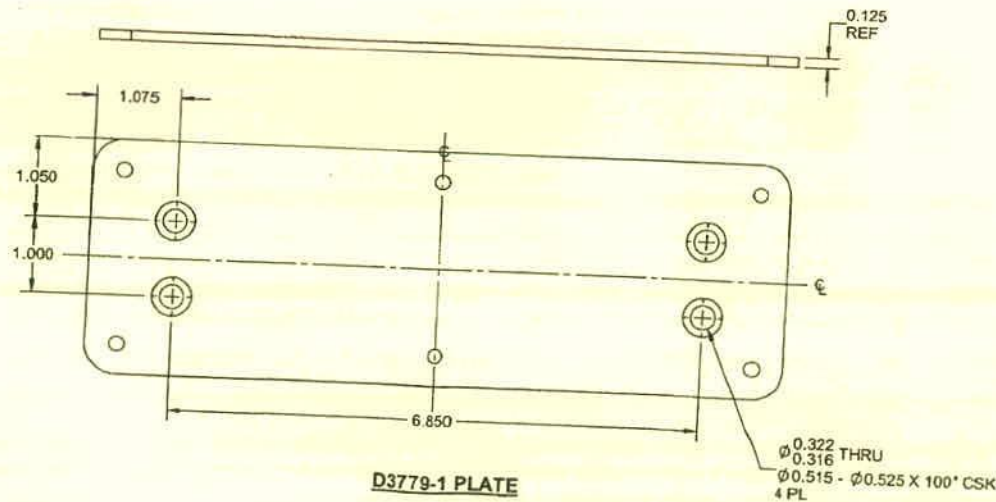
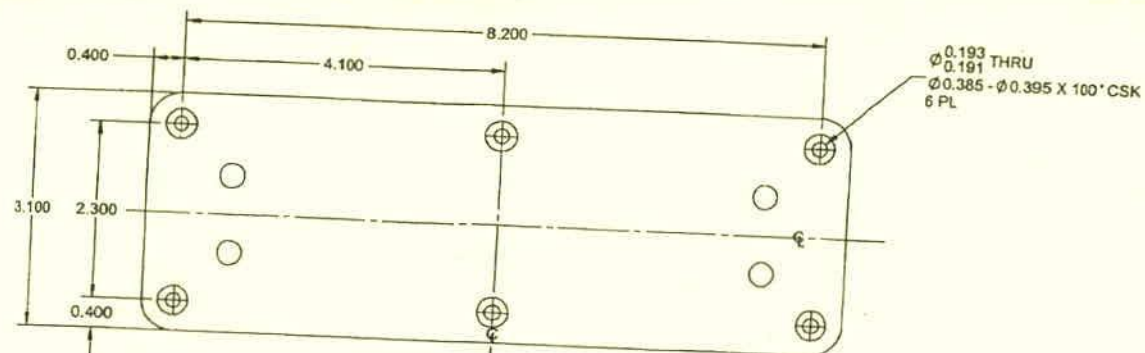
**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-XXX" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: D3779-041: 0.71 lbs
D3779-043: 1.14 lbs
- 8) RIVETS TO BE PEENED AND GROUND FLUSH.
- 9) FORMED TO FIT D3779-7 HANDLE DURING ASSEMBLY.

RELEASED
2012-07-23

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	ES	D3779	SHEET 2 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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D3779-1 PLATE

Ø 0.193 THRU
Ø 0.191
Ø 0.385 - Ø 0.395 X 100" CSK
6 PL

0.125
REF

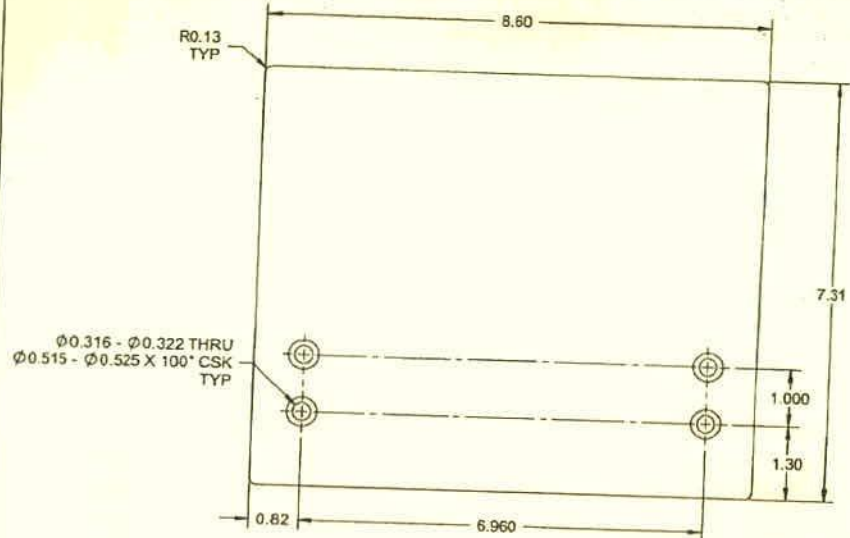
Ø 0.322 THRU
Ø 0.316
Ø 0.515 - Ø 0.525 X 100" CSK
4 PL

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2012-07-23

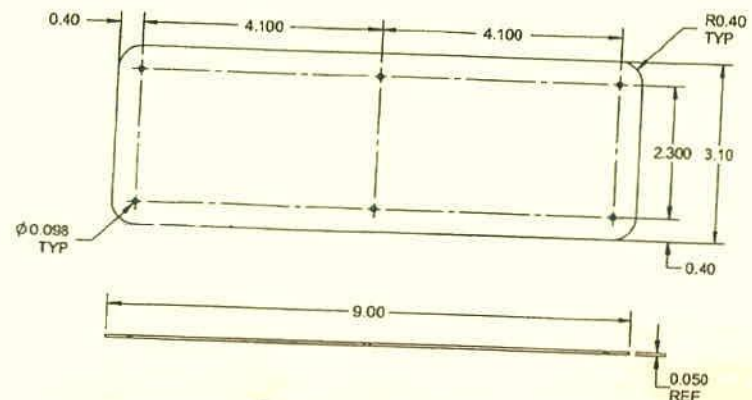
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

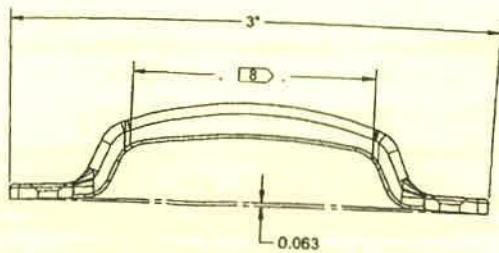
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DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	G.D.	D3779	SHEET 3 OF 4
APPROVED	W.P.	TITLE	SCALE
DE APPR.	W.P.	HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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D3779-5 PLATE



D3779-3 DOUBLER PLATE



D3779-7 HANDLE, MODIFIED

- NOTES:**
- 1) MATERIAL:
D3779-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.050)
D3779-5: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)
D3779-7: MADE FROM D3203-1
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: D3779-3: IDENTIFY WITH DART P/N "D3779-3" AND B/N "BXXXXX" PER DART QSI 044 6.1
D3779-5: NONE
D3779-7: NONE
 - 7) WEIGHT: D3779-3: 0.14 lbs
D3779-5: 0.76 lbs
D3779-7: 0.38 lbs
 - 8) BEND HANDLE THROUGH THIS AREA ONLY

RELEASED
2012-07-23

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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